

Date: Thursday, 10/08/2006 10:02:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR BODY
Job Number	: 28133	Part Number	: D2094
Estimate Number	: 11975	Drawing Number	: D2094 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 10/08/2006 S.O. No. : NJA	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 31/08/2006
Previous Run	: N/A	Qty:	25
Written By	: <i>[Signature]</i>	Um:	Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. B 99.01.20 Re-format DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2061	Aspirator

Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)

Aspirator

Pick:

Qty	Part number	Description	Batch
1	D2061	Aspirator Body	<i>28138</i>

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill 4 flange holes as per Dwg D2092/93/94 using Drill Jig DT 8262

FF 06.09.2025

Cut edges as per Dwg D2095 using Jig DT 8263

Drill 5/16 hole for jet as per Dwg D2092/93/94 using Drill Jig DT 8296

Deburr

FF 06-11-02 25

Clean and polish with water and thinner

3.0 QC5 INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

06/11/02 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:02:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR BODY

Job Number: 28133

Part Number: D2094

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 214

10/08/06 10:22:28

5.0	DC	DOCUMENT CONTROL
-----	----	------------------



(25)

Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/11/03

Job Completion



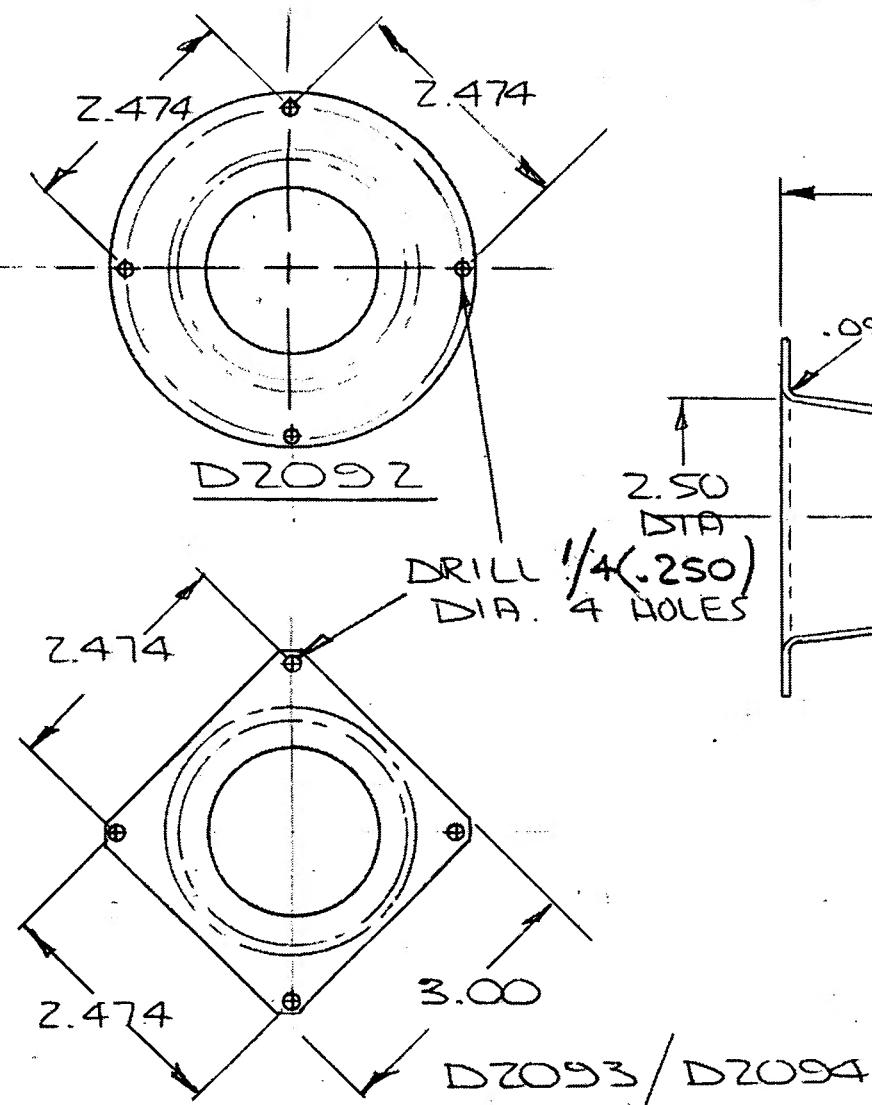
10/06/06 10:03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRILL 5/16 (.312) DIA THRU
AS SHOWN ON D2092
AND D2093. ROTATE 45°
ON D2094.

MATERIAL: 1100-O, .063
SPIN FROM
SHEET STOCK

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR				
	DRAWN			BASIC CODE	DIA. DASH NO. #HEAD NEAR SIDE #HEAD FAR SIDE	CONTRACT NO.	DART DART AERO ACCESSORIES INC. VANCOUVER, CANADA						
	APPROVED			D=DIMPLE DGT=DIGIT NO. OF SHEETS C=COUNTERSINK	LENGTH DASH NO. #W=SPOTWELD	DRAWN					DATE		
1/14/97 10:20 AM 70-1020	DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED				BASIC CODES					DESIGN	1992	
		GENERAL		LIMITS		8J-MS20470AD 98-MS20478AD		STRESS	TITLE				
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 1/16 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. - 5 - 7742 5. HOLES PER INCH 10387		1. TOLERANCES — .001 ± .030 2. ANGLES ± .010 3. PARALLELISM .0075 4. ECCENTRICITY .005 MAX. 5. POSITION ABOUT ALL W/C CENTRE LINES .003				CHECKED	CODE	DWG NO.	REV.		
		REPORT ALL DISCREPANCIES — DO NOT SCALE										1:2	SET

